

**Work Order ID 68599**

Monday, April 18, 2011 12:29:37 PM



Page 1

Item ID: D3245-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 4/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *M*Date: *11/04/18*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3245	Rev B

100  

Pick Kit

0.00

*E/S 11/04/18 (6)*

Packaging

Memo

0.00

Packaging

110  

Small Fab

0.00

*E/S 11/04/27 (6)*

Small Fab

Memo

0.00

Small Fab

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245□be careful  
when countersinking...mat'l very thin120  

QC5- Inspect part completeness to step on W/O

0.00

*S 11/04/27*

0.00

QC

Quality Control

*(6)*

*-041*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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# Picklist Print

Page 1

Monday, April 18, 2011 12:29:44 PM

Work Order ID: 68599



Parent Item: D3245-041



Parent Item Name: Access Panel Assembly

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y		Purchased	No			110	Each	146.0000	8	48		EJS 11/04/19	

RIGID RECEPTACLE

Location      Loc Qty      Loc Code

ST399                  46

105729                  2

117204\*                  24

19688                  20

ST400                  100

117358\*-                  100

110      Each      0.0000

B67547      (6x)

D3245-1



Panel

Manufactured      No

D3245-5



Door

Manufactured      No

MS20427M3-3



Rivet

Purchased      No

Location      Loc Qty      Loc Code

GA                  5

47610                  5

110      Each      1,638.000

16

EJS 11/04/19

Location      Loc Qty      Loc Code

ST318                  1638

117206                  1638

96

EJS 11/04/19

96

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Page 2

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Work Order ID: 68599



Parent Item: D3245-041



Parent Item Name: Access Panel Assembly

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

MS20615M3-3



Purchased

No

110

Each

200.0000

9

54



Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	200	
111650	100	
116188	100	

*E3245-041*

54

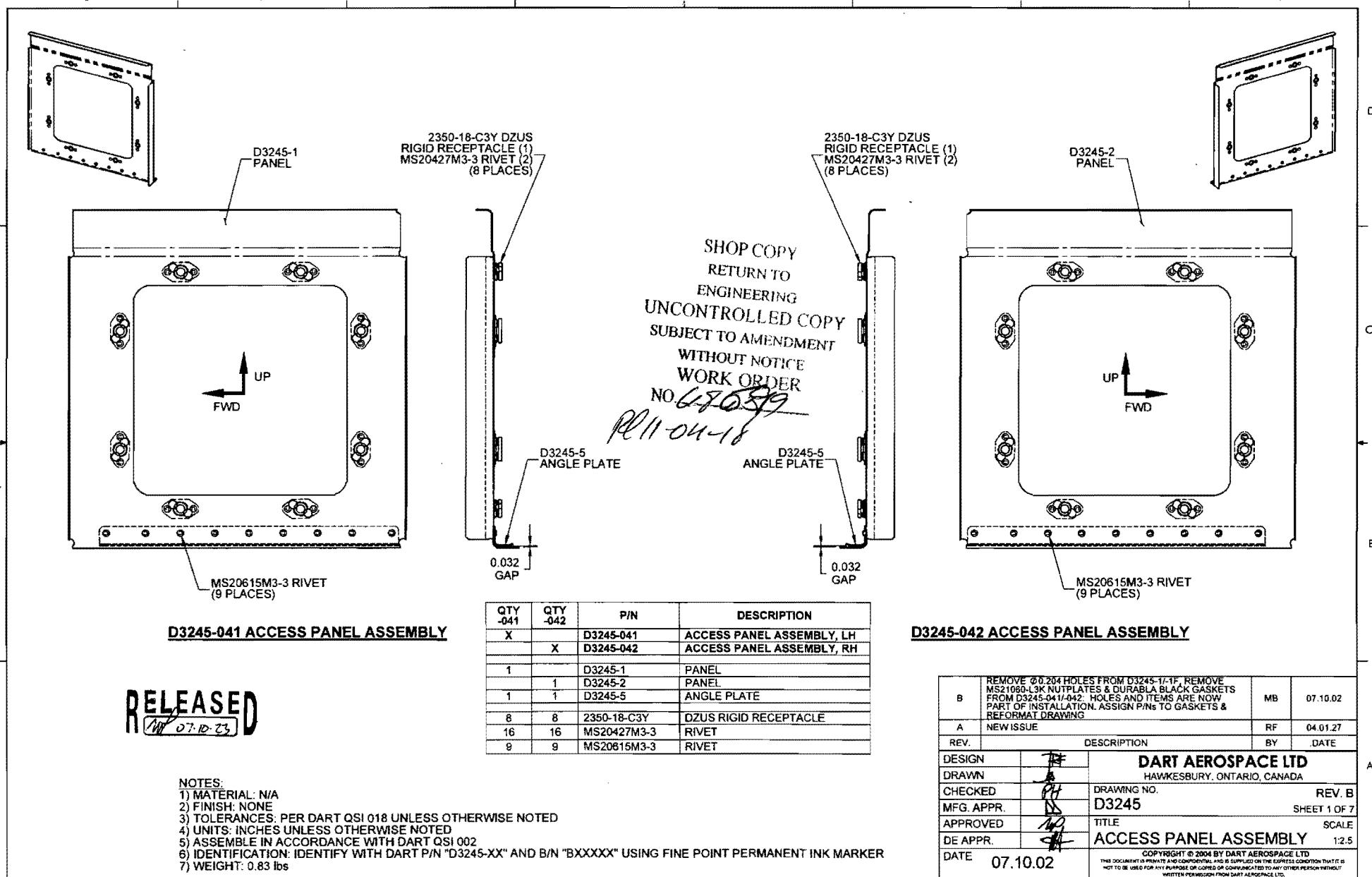
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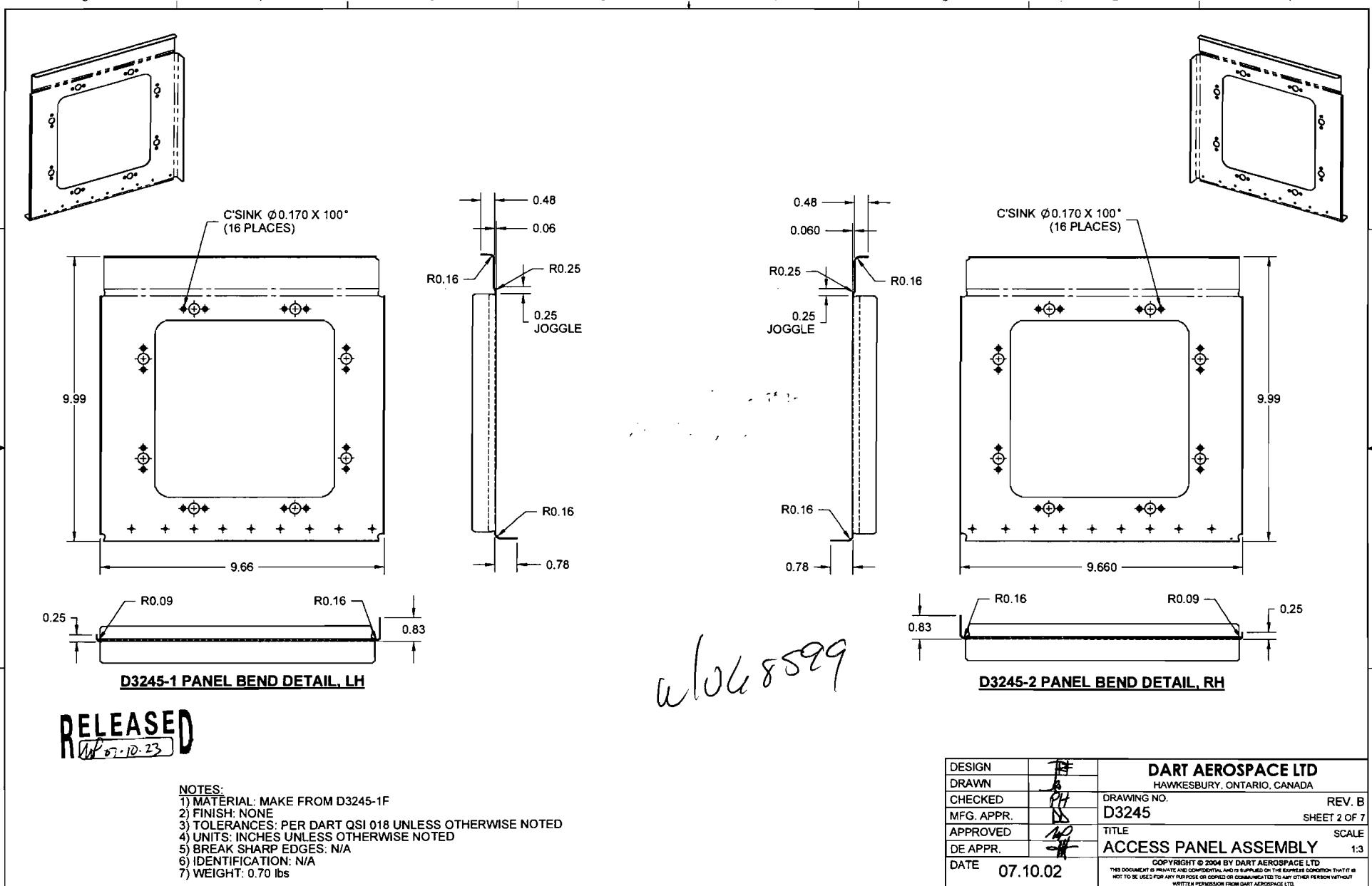
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CHECKED	<i>#</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>#</i>	D3245	SHEET 2 OF 7
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.	<i>#</i>	ACCESS PANEL ASSEMBLY	
DATE	07.10.02		

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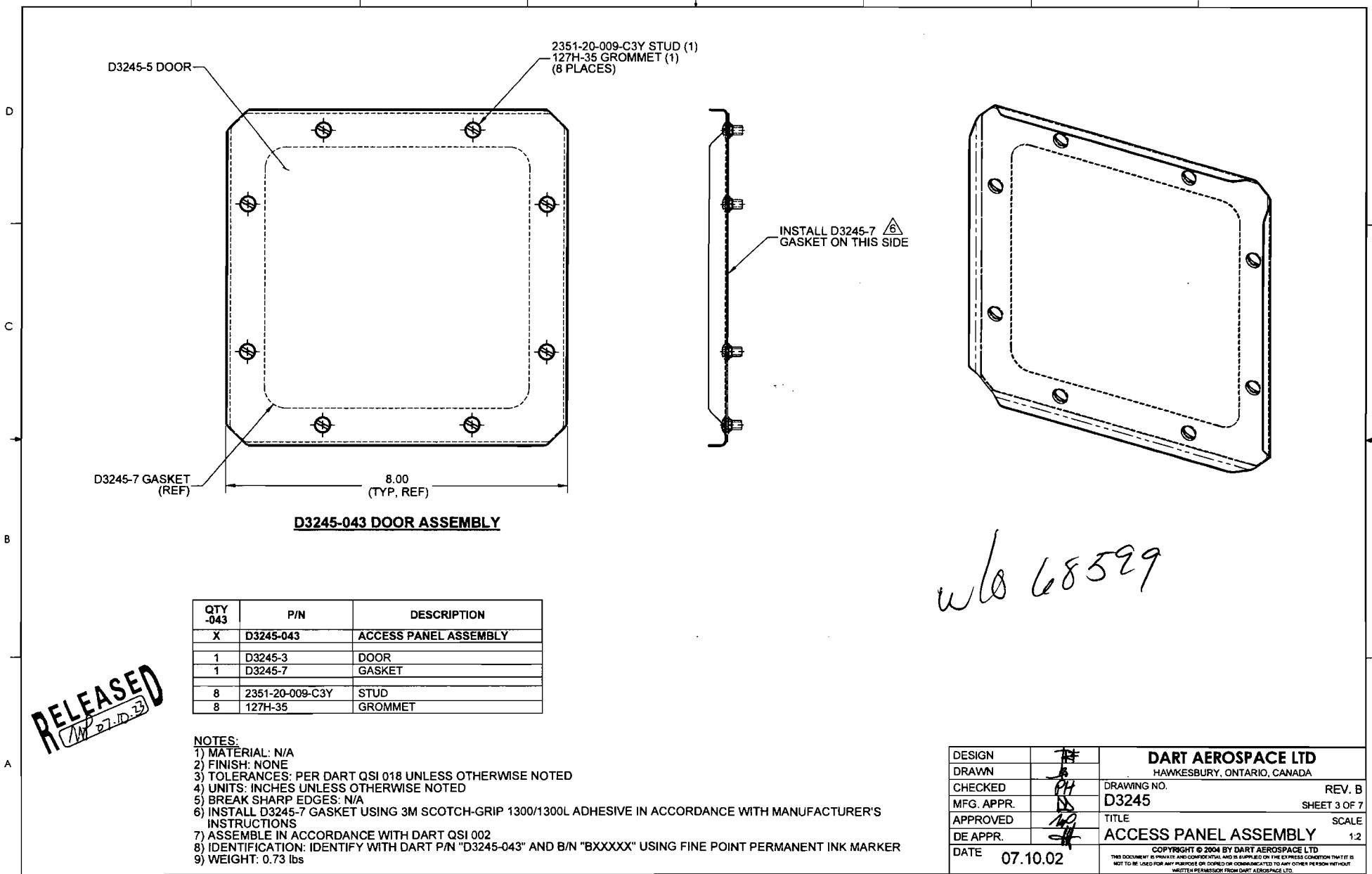
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8 7 6 5 4 3 2 1



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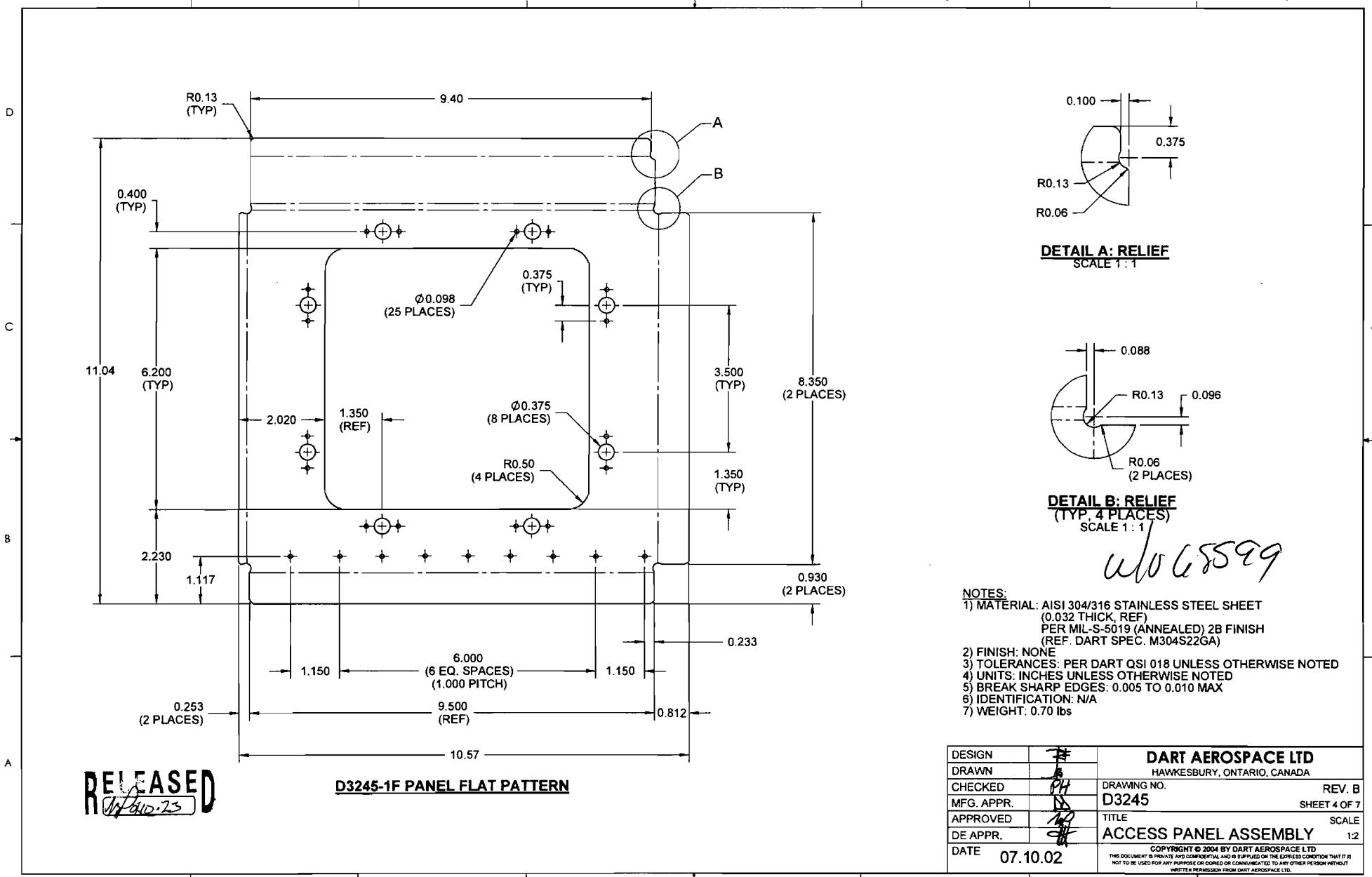
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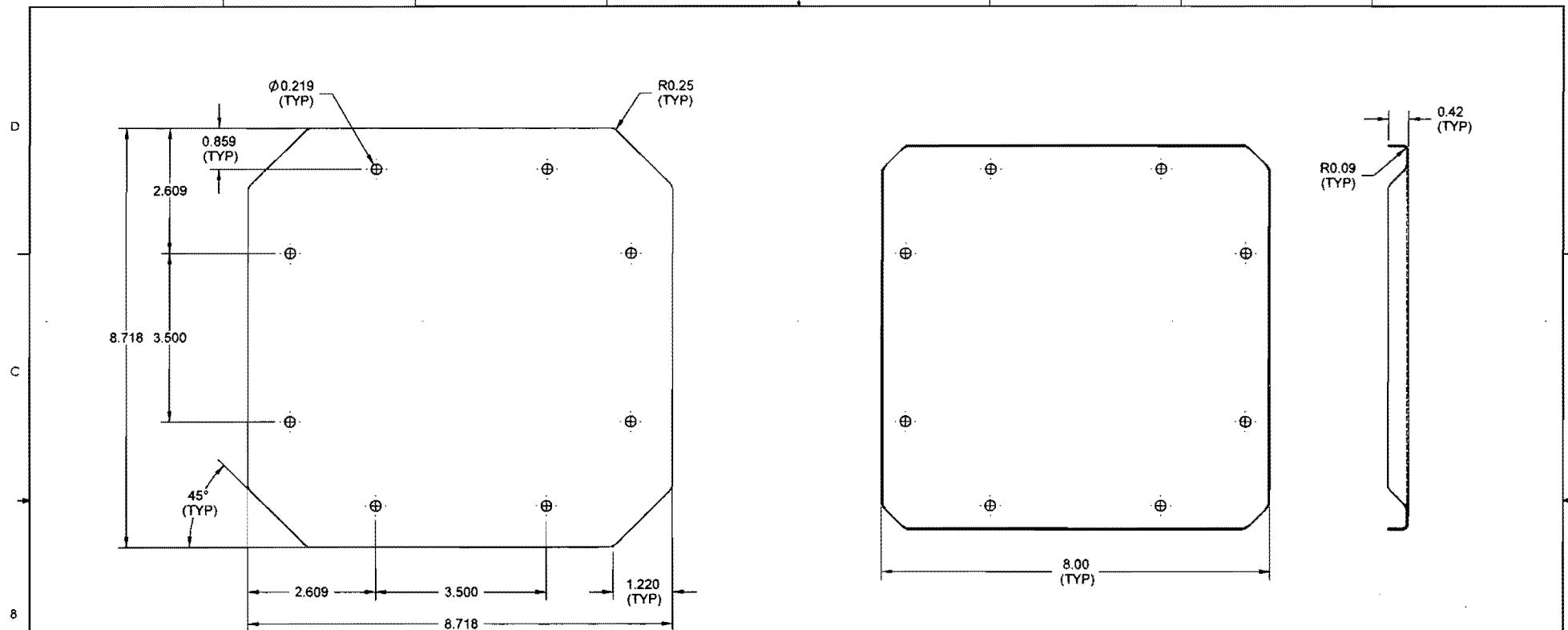
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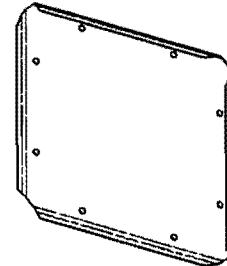
8 7 6 5 4 3 2 1

D3245-3F DOOR FLAT PATTERND3245-3 DOOR BENDING DETAIL

**RELEASED**  
*07.10.02*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



DESIGN	<i>TR</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	
MFG. APPR.	<i>ND</i>	REV. B	
APPROVED	<i>AP</i>	D3245	
DE APPR.	<i>ND</i>	TITLE	SCALE
DATE	07.10.02	ACCESS PANEL ASSEMBLY	

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8 7 6 5 4 3 2 1

D

C

B

A

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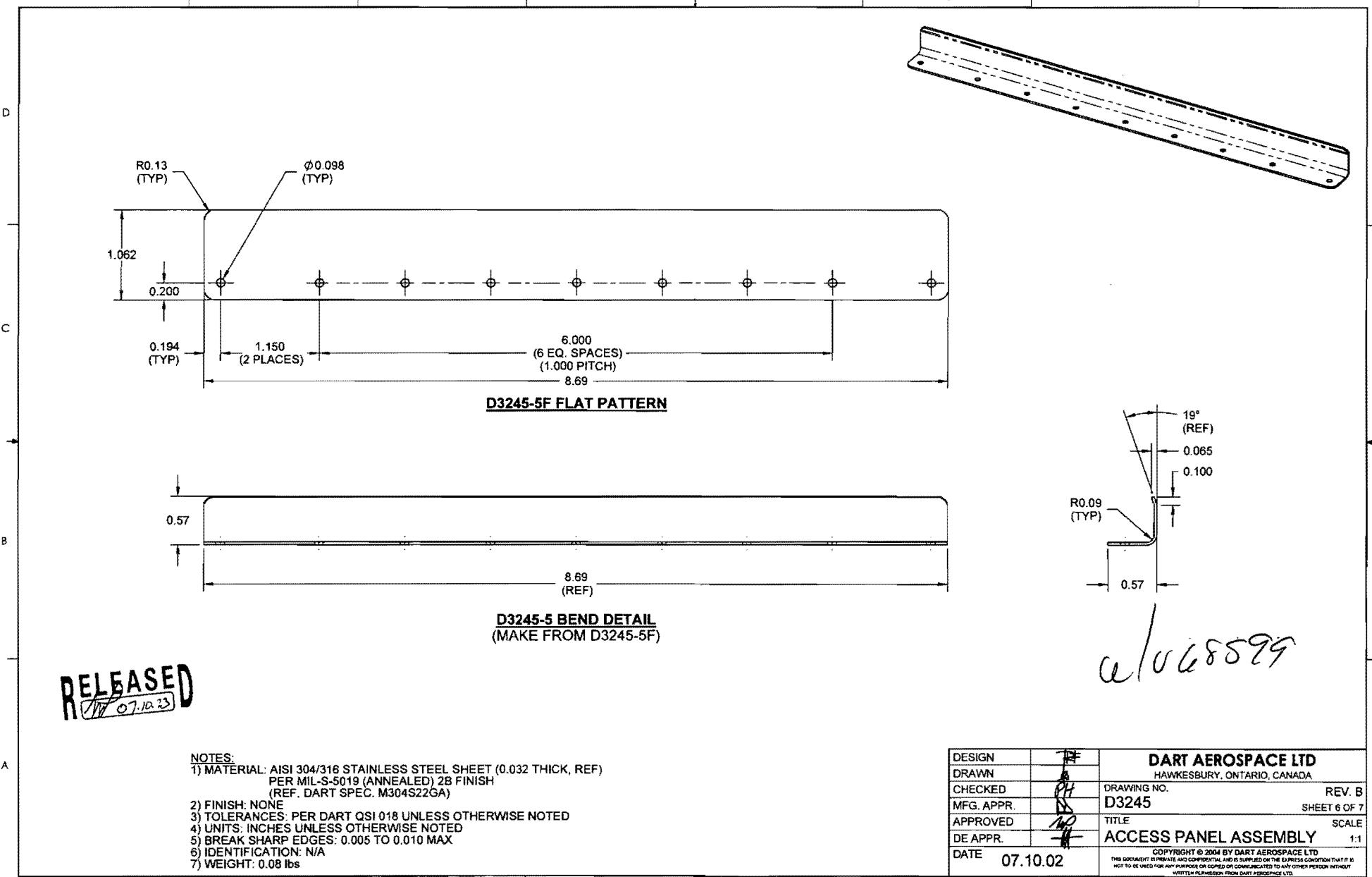
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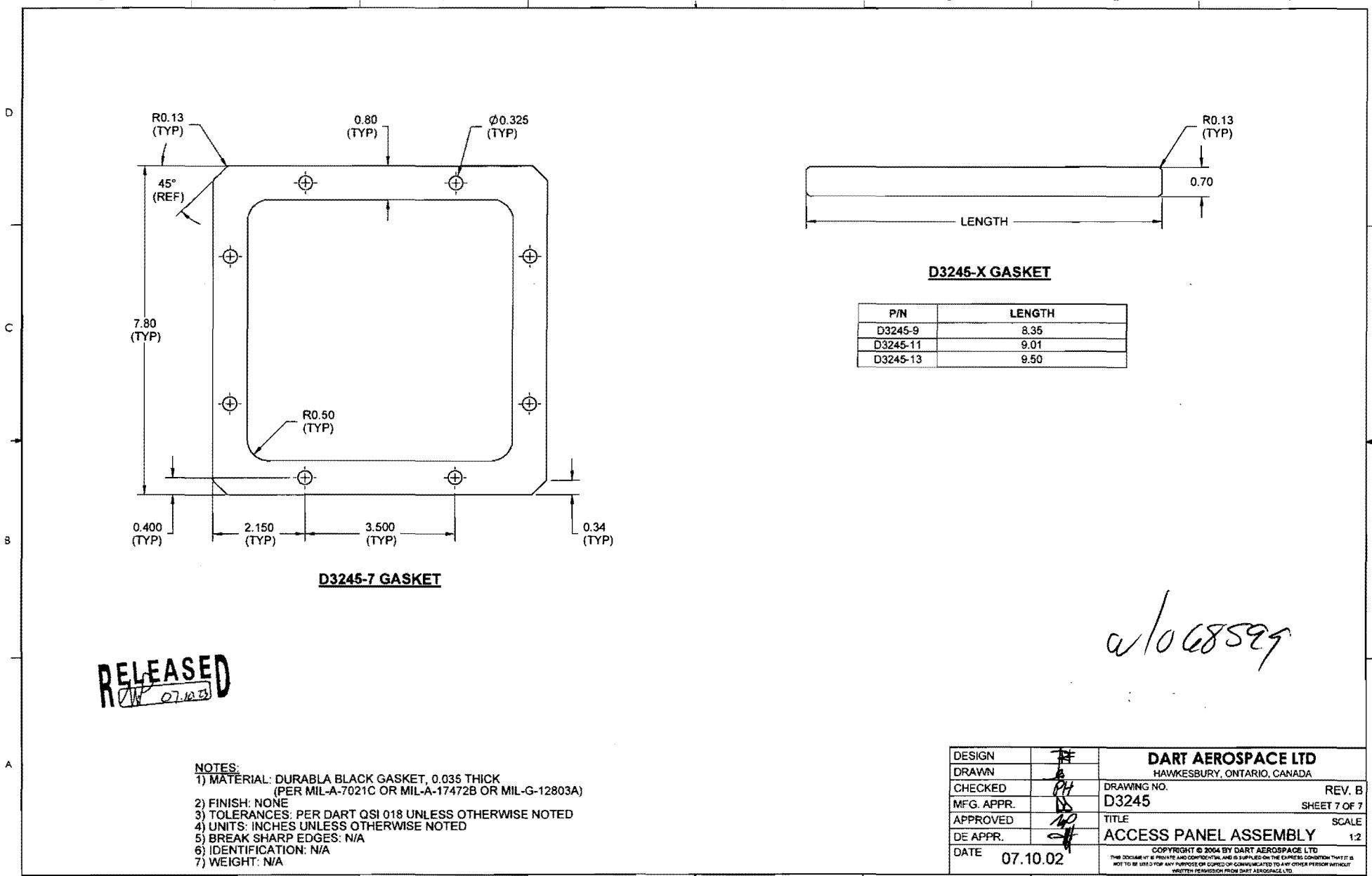
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